

shop 24602

Work Order ID 80403

80403

February-21-12 7:59:50 AM

Item ID: D4382-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angled Bearpaw Clamp

Start Date: 2/21/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/22/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4382

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-21

13

B12-2-21

Work Order ID 80403

80403

Page 2

February-21-12 7:59:50 AM

Item ID: D4382-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

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Start Date: 2/21/12

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Cust Item ID:

Required Date: 2/22/12

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12 - 02 - 21 (13)

130

Form as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

SB 12/02/21

(13)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

12 - 02 - 21 (13)

Work Order ID 80403

80403

Page 3

February-21-12 7:59:50 AM

Item ID: D4382-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Angled Bearpaw Clamp

Stop *NS2*

Start Date: 2/21/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/22/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: ST449 0.00

150

Packaging

Memo

0.00

Packaging

(13) SP 12-02-22

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

M.L.J. 12/02/22

12-02-22
(13)

Picklist Print

February-21-12 7:59:50 AM

Page 1

Work Order ID: 80403

Parent Item: D4382-1

Parent Item Name: Angled Bearpaw Clamp

Start Date: 2/21/12

Required Date: 2/22/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No			100	sf	103.6000	0.05513	0.5803158			

B 12-2-21

Location

Loc Qty

Loc Code

MAT020

103.6

117933

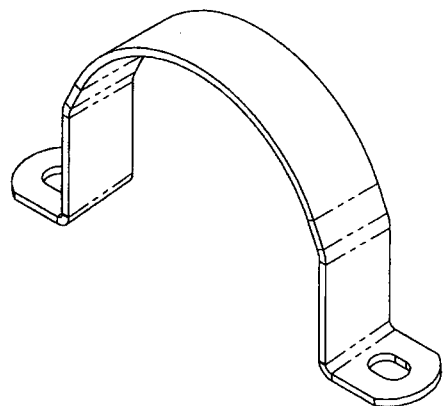
7.6

119276

96

117933

(13)



D4382-1 ANGLED BEARPAW CLAMP

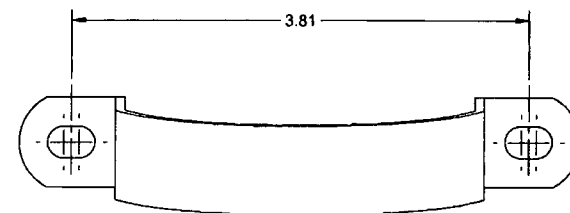
804102

RELEASED
2011-04-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4382-1" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.13 lbs





A		NEW ISSUE		AJS	11.03.28
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		AJS			
CHECKED			DRAWING NO.	REV. A	
MFG. APPR.			D4382		SHEET 1 OF 2
APPROVED			TITLE	SCALE	
DE APPR.			ANGLED BEARPAW CLAMP	NTS	
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VIEW A-A D3-2



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2011-04-21
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